

Work Order ID 144965

Thursday, April 28, 2016 10:05:24 AM

144965

Ship May 3rd

Page 1

Item ID: D205-702-353

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shoulder Harness, 3-Point Att., Inertia Reel Continuous Belt, 4 Man Aft Facing

Start Date: 4/28/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/3/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: UNE Date: 16-4-27 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9511	A

100	DOCUMENT CONTROL	0.00	DAS 9-89						
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPP D205-702-353 CHG001							

DAS
28
9-89

ML 16-0502

MAY 03 2016

110	Pick Kit	0.00							
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110									
Packaging	Memo	0.00							
Packaging									

APR 29 2016

DAS DAS
27
9-89 9-89

120	QC4- 100% Inspect kits for completeness	0.00							
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120									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89

MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

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Page 2

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Item Name: Shoulder Harness, 3-Point Att., Inertia Reel Continuous Belt, 4 Man Aft Facing

Start Date: 4/28/2016 Start Qty: 1.00 ***1***

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Required Date: 5/3/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D205-702-353

Location: FL 029

PPP Rev: _____

0.00

0.00

DAS
28
9-89

MAY 03 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ

MAY 03 2016

MLJ

MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Thursday, April 28, 2016 10:05:21 AM

Page 1/

144965

D205-702-353

Required Date: 5/3/2016

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.04.30 verified:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-702-311 *D412-702-311* Harness Assembly		Manufactured	No			110	Each	0.0000	2	2			
D412-702-313 *D412-702-313* Harness Assy		Manufactured	No			110	Each	0.0000	2	2			
D3572-043 *D3572-043* Guide Assembly (Uh-1)		Manufactured	No			110	Each	1.0000	1	1			
					<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>			
					Mezz		1						
					47642		1						
D3572-044 *D3572-044* Guide Assembly (Uh-1)		Manufactured	No			110	Each	1.0000	1	1			
					<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>			
					Mezz		1						
					47643		1						
AN4-16A *AN4-16A* Bolt		Purchased	No			110	Each	208.0000	6	6			
					<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>			
					FG		5						
					121541		5						
					ST343		203						
					M134509		80						
					M134606		123						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Thursday, April 28, 2016 10:05:22 AM

Work Order ID: 144965

144965

Parent Item: D205-702-353

D205-702-353

Parent Item Name: Shoulder Harness, 3-Point Att., Inertia Reel Continuous Belt, 4 Man Aft Facing

Start Date: 4/28/2016

Required Date: 5/3/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

3,062.000

12

12

NAS1149D0463.1

WASHER

**

DAS
27
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

328

M132035

21

M134508

307

ST260a

1600

M134508

600

M134634

1000

ST263

146

M134039

29

M134573

117

ST269

988

M132317

100

M132677

888

12

MS21042L4

Purchased

No

110

Each

1,572.000

6

6

MS21042L4

Locknut

**

DAS
6
9-89 DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

283

m133769

283

ST303

1192

m134055

1

m134509

191

m134606

1000

ST305

97

m130922

97

6

APR 29 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Ship May 3rd

Page 1

Item ID: D205-702-353

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shoulder Harness, 3-Point Att., Inertia Reel Continuous Belt, 4 Man Aft Facing

Start Date: 4/28/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/3/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: UNUE Date: 16-4-27 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9511	A

100

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D205-702-353 CHG001

MLJ MAY 02 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

APR 29 2016

DSI
9-55

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

11N Rev. F

DSI 9511

TABLE 3

QTY -337	QTY -353	Part Number	Description
X		D214-702-337	Dart 5-Man 3 Point Aft Facing Shoulder Harness Kit, for 214 Aircraft
	X	D205-702-353	Dart 4-Man 3 Point Aft Facing Shoulder Harness Kit, for UH-1 Aircraft
1	2	D412-702-311	HARNESS ASSEMBLY (NEW) --> SEE TABLE 2
1	2	D412-702-313	HARNESS ASSEMBLY (NEW) --> SEE TABLE 2
1		D412-702-321	HARNESS ASSEMBLY (NEW) --> SEE TABLE 2
1		D412-702-323	HARNESS ASSEMBLY (NEW) --> SEE TABLE 2
1		D412-702-319	HARNESS ASSEMBLY (NEW)
1*		D3925-041	BRACKET
1*		D4088-043	SHOULDER HARNESS ASSEMBLY (NEW)
4*		MS24694S50	BOLT
4*		AN960JD10L	WASHER
4*		MS21042L3	NUT
	1	D3572-043	GUIDE ASSY
	1	D3572-044	GUIDE ASSY
1		D3920-041	SEATBELT GUIDE ASSEMBLY
2		D3920-5	SEATBELT GUIDE
1	6	AN4-16A	BOLT
1		AN4-21A	BOLT
7		AN4-25A	BOLT
18	12	AN960JD416	WASHER
9	6	MS21042L4	NUT

* denotes that part is included in assembly above

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 10.03.22
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9511	SHEET 6 OF 6
APPROVED	109	TITLE	SCALE
DE APPR.		NEW SHOULDER HARNESS KITS	NTS
DATE	10.03.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	